

pulse & pulse interface

Spruing Tips



2g (1 x 2g)	ingot for	0.6g wax weight
4g (2 x 2g)	ingots for	1.2g wax weight
5g (1 x 5g)	ingot for	1.5g wax weight
7g (1 x 2g) & (1x5g)	ingots for	2.1g wax weight
10g (2 x 5g)	ingots for	3.0g wax weight

- Weigh ring base
- Weigh opaque framework
- Wax to opaque framework
- Sprue with 8 gauge wire, wax to thickest section of the pattern
 - The angle of the fixed objects to the vertical axis is approximately 20°
 - No part of the wax pattern should be any closer than 5mm to the edge of the ring
- Weigh base with sprued units. Subtract weight of the base and opaque framework to get wax weight
- Refer to table for details on the # of ingots needed

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